

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 28508

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D34439	PIN
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3443-9	Pin

Batch

B29673 x 5
B28166 x 1

ml

7.0	AN4CH3	SS Bolt
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN4CH3	BOLT
A/R	MS20995c25e	Lockwire

Batch

M19390 x 6 (88)
M101537

ml

ml

8.0	AN4C14	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4C14	BOLT

Batch

M19096 x 3

ml

9.0	D34547	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-7	Bushing

Batch

B28170 x 6

ml

10.0	AN3104	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN310-4	Nut

Batch

M19356
M19096 x 3

ml

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11.0 MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	<u>M102073X3</u>

ml

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	<u>B28171X0</u>

ml

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	<u>M30308X2</u>

ml

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	<u>B25536X1</u>

ml

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	<u>M16941X3</u>

ml

Date: Wednesday, 9/13/2006 4:20:50 PM
User: Kim Johnston

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Seq. #: Machine Or Operation:

Description :

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo 07/01/19 ①

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0 D34541 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	<u>D28167-1</u>

19.0 D34543 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	<u>D28168-1</u>

20.0 D34545 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	<u>D28169-1</u>

21.0 D34551 Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
6	D3455-1	Spacer	<u>D28171-1</u>

EJ 07/01/19
07/01/20

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Seq. #:	Machine Or Operation:	Description :
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22.0	D34553	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-3	Spacer	<i>628172</i> ✓

23.0	D3462042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3462-042	Bracket ass'y	<i>627191</i> - <i>328472</i>

24.0	AN3104	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	<i>119356</i> ✓

25.0	AN3105	NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-5	Nut	<i>119096</i> ✓

26.0	AN3C5A	Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	<i>110189</i> ✓

8/5/04/01/18

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27.0	AN44C12	eyebolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN44-C12	Eyebolt	<u>119649</u> ✓

28.0	AN4C15	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	<u>119213</u> ✓

29.0	AN5C11	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	<u>119096</u> ✓

30.0	AN5C15	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	<u>119213</u> ✓

31.0	AN960C10	WASHER
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Comment: Qty.: 7.0000 EACH(s)/Unit Total : 21.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	<u>110106</u> ✓

E. Bostrom 9/19

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Job Number:			
			
Seq. #:	Machine Or Operation:		Description :
32.0	AN960C516		WASHER
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
1	AN960C516	Washer	<u>111697</u> ✓
33.0	MS210433		Nut
			
Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
3	MS21043-3	Nut	<u>4102404</u> ✓
34.0	MS24665227		COTTER PIN
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	<u>1102073</u> ✓
35.0	MS24665229		COTTER PIN
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	<u>1119096</u> ✓
36.0	NAS1515H5		Washer
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
1	NAS1515H5	Washer	<u>4101064</u> ✓
			<u>CB 09/07/06</u>

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Description :

37.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.17

?

2 N/A
7/01/22
change made

38.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Test fit on aircraft in Eng. lab.

?

39.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/01/19

①

40.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location: _____

PPP Rev: _____

7/01/19

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41.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/01/19

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Job Completion



7/01/19